

Work Order ID 80181

February-13-12 10:41:53 AM

\*80181\*

Page 1

Item ID: D350-636-014

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop

\*NS2\*

Start Date: 13/02/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 13/02/13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100 0.00

\*100\*

DOCUMENT CONTROL

DC

Document Control

Memo 0.00

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

for M.L.J 12-4-20

13 Skidtube

80181

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 80181**

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**\*80181\***

Page 2

Item ID: D350-636-014

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop

**\*NS2\***Start Date: 13/02/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00 **\*1\***

Customer:

**Reference:**

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
						Stop	<b>*NR2*</b>
	QC:	Date:	SPC (Y/N):	Date:			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 <b>*110*</b> Skidtubes	Skidtubes  Memo	0.00							

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-4 details). Drill using drill Jig DT8150 & DT8864A for first side only DT8864B for second side (detail B)

7- Clecko DT8864B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

B 12/04/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 80181

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Item ID: D350-636-014

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop

\*NS2\*

Start Date: 13/02/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004

A/R Aluminum Rod batch: MD20164

12-Grind welds flush as per Dwg D2750

120

\*120\*

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S.2/10/10

130

\*130\*

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S.2/10/10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D350-636-014

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Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop

\*NS2\*

Start Date: 13/02/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

140

Chemical Conversion Coat per QSI005 4.1

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

\*140\*

HandFinish

Hand Finishing

150

\*150\*

QC

Quality Control

~~QC3- Inspect Part Finish~~

0.00

~~QC7~~

0.00

1 0 CF 12-04-10

①

SAD 12-04-10

Memo

Memo

W/O: 80180		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12-04-11	150	Change Qc3 to Qc7	SAD					

Part No: D350-636-014 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Item ID: D350-636-014

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop

**\*NS2\***

Start Date: 13/02/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00

**\*1\***

Customer:

**Reference:**

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\*****Sequence ID/  
Work Center ID****Operation  
Description****Set Up/  
Run Hours****Tool ID****Tool #****Plan  
Code****Accept  
Qty****Reject  
Qty****Reject  
Number****Insp.  
Stamp**

160

**\*160\***

Skidtubes

Skidtubes

0.00

Skidtubes

**Memo**

0.00

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 1A04/3  
exp. date: 12-06-137- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 11)A/R Aluminum Rod batch: m120854

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

*2011-04-11**3 BE 064/12**CF 12-4-16**3/CC 17/04/16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D350-636-014

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\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop

\*NS2\*

Start Date: 13/02/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

\*170\*

QC

Quality Control

5/17/17

180

QC5- Inspect part completeness to step on W/O

0.00

\*180\*

QC

Quality Control

5/17/17

190

Pressure Wash per QSI005 4.3

0.00

\*190\*

HandFinish

Hand Finishing

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

16 12-4/17 BL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 80181

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Item ID: D350-636-014

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop

\*NS2\*

Start Date: 13/02/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

\*200\*

Powdercoat

Powder Coating

W121134

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

IX ✓

M-  
12/04/18

Memo

9:00 0.00  
3200F  
9:30

210

\*210\*

QC

Quality Control

QC3- Inspect Part Finish

0.00

IX ✓

M-  
12/04/18

Memo

0.00

✓ Inspect for foreign object per QSI 024

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID 80181

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Item ID: D350-636-014

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop

\*NS2\*

Start Date: 13/02/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

\*230\*

HandFinish

Hand Finishing

HandFinishing

0.00

1

~~1~~

SP

13/01/19

Memo

0.00

1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: M110348

3-Assemble tube hardware as per dwg D2750 sikaflex batch: 12/22

13/01

4-Inspect For Foreign Objects

5-Spray inside of tube with "LPS-3" batch: N/A

6-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: 121221

EXP DATE: 13/01

7-assemble o'ring to plug as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: M110348

8-Coat all exposed fasteners with "LPS Procyon" batch: 114596

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Work Order ID 80181

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Item ID: D350-636-014

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube RH

Stop

\*NS2\*

Start Date: 13/02/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

240

QC5- Inspect part completeness to step on W/O

\*240\*

QC

Quality Control

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.00

Spaltw

250

Pick Kit

0.00

\*250\*

Packaging

Packaging

Memo

0.00

12/04/2013

260

QC4- 100% Inspect kits for completeness

0.00

\*260\*

QC

Quality Control

Spaltw

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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\*NS2\*

Start Date: 13/02/2012 Start Qty: 1.00 \*1\*

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Required Date: 27/02/2012 Req'd Qty: 1.00 \*1\*

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Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

270

\*270\*

Packaging

Packaging

0.00

0.00

Recu I  
72

P 10

12/4/2012

280

\*280\*

QC

QC21- Final Inspection - Work Order Release

0.00

0.00

Quality Control

12/4/23

12/4/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

February-13-12 10:41:56 AM

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Work Order ID: 80181

\*80181\*  
\*D350-636-014\*

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H02.09.25Rearranged procedure stepsKJ

IPP Rev:I05.12.08Rearranged procedure stepsEC

IPP Rev:J06.03.30Per rev. D EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

IPP Rev:M 08-09-23 revF as per dwg DD verified by:ec IPP Rev:N

10.06.22 revise seq110 DD verf:EC IPP Rev:O 10.10.01 as per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT		Manufactured	No			110	Each	12.0000	1	1	1	1	12/04/09

\*D2600-3-BENT\*

Extrusion Bent

Location	Loc Qty	Loc Code
LG	82347	12
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
77623	1	

D2739

Manufactured No

160 Each 3.0000

\*\*

1 1

\*D2739\*

350 I Beam

Location	Loc Qty	Loc Code
LG	3	
72155	1	
78898	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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# Picklist Print

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Work Order ID: 80181

**\*80181\***  
**\*D350-636-014\***

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

172.0000

8

8

\*\*

**\*D2743\***

Crossbolt Spacer

*BE 12/04/12*  
*B 81965 x 8*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	172	
67766	4	
68251	3	
73403	64	
74445	2	
78603	99	

D2744

Manufactured No

160

Each

20.0000

1

1

\*\*

**\*D2744\***

Cap

*BE 12/04/10*  
*B 78900 x 1*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	20	
62715	1	
70881	12	
71861	7	

D3490-1

Manufactured No

160

Each

57.0000

4

4

\*\*

**\*D3490-1\***

Cross Bolt Spacer

*BE 12/04/12*  
*B 81976 x 4*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	57	
62450	2	
74875	4	
77042	8	
78793	43	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

**Picklist Print**

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Page 3

**Work Order ID:** 80181**\*80181\*****Parent Item:** D350-636-014**\*D350-636-014\*****Parent Item Name:** Skidtube RH**Start Date:** 13/02/2012**Required Date:** 27/02/2012**Start Qty:** 1.00**Required Qty:** 1.00

D3490-5

Manufactured No

160

Each

20.0000

4

4

\*\*

**\*D3490-5\***

Cross Bolt Spacer

BE13/04/12

ALS4-1032-225

Purchased No

230

Each

1,408.000

38

38

\*\*

**\*AI S4-1032-225\***

Insert

38 ~~38~~ ~~28~~ ~~28~~ 28 04/04/19

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST281 121269✓	1031	
108696	146	
110768	62	
118386	55	
118966	68	
120671	700	
ST282	377	
120410	200	
120451	177	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 80181

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

**\*80181\***  
**\*D350-636-014\***

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased No

230 Each 1,058.000

34 34

\*\*

34

(PP)

12/04/19

**\*AN3C5A\***

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	7	
115835	7	
ST350	1051	
116419	28	
117343	13	
117764	7	
117872	2	
119127	32	
119749	27	
120423 ✓	942	

AN3C6A

Purchased No

230 Each 332.0000

4

4

\*\*

4

(PP)

12/04/19

**\*AN3C6A\***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	1	
111982	1	
ST351	331	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	242	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 80181

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

\*80181\*  
\*D350-636-014\*

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased No

230 Each

98.0000

4

4

\*\*

4

(DP)

12/04/19

\*AN6C44A\*

BOLT

Location	Loc Qty	Loc Code
FG	2	
103964	2	
ST343	96	
120095	16	
120143 ✓	25	
120465	27	
120641	28	

AN8C35A

Purchased No

230 Each

66.0000

1

1

\*\*

1

(DP)

12/04/19

\*AN8C35A\*

BOLT

Location	Loc Qty	Loc Code
FP002	65	
115960	1	
117834	10	
118286 ✓	54	
ST346	1	
114442	0	
115188	0	
115960	1	

AN960C10L

X NAS1149C0332 ✓ Purchased R

No

230 Each

0.0000

38

38

\*\*

(DP)

12/04/19

\*AN960C10L \*

washer

121255

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80181

\*80181\*  
\*D350-636-014\*

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230 Each

48.0000

8

8

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8

(28)

02/04/19

\*D2745\*

Bushing

Location	Loc Qty	Loc Code
FP001	81964 ✓	48
69529	1	
76142	1	
78597	46	

D3488-042

Manufactured No

230 Each

20.0000

1

1

\*\*

1

(28)

12/04/19

\*D3488-042\*

Blade Fitting Assembly, RH

Location	Loc Qty	Loc Code
FP002	20	
62003	1	
71883	1	
75068 ✓	9	
77015	9	

D3492-1

Manufactured No

230 Each

138.0000

8

8

\*\*

8

(28)

12/04/19

\*D3492-1\*

Plug

Location	Loc Qty	Loc Code
FP002	81963 ✓	138
69531	8	
74444	2	
76235	28	
77037	100	

D3492-5

Manufactured No

230 Each

32.0000

8

8

\*\*

8

(28)

12/04/19

\*D3492-5\*

Plug

Location	Loc Qty	Loc Code
FP002	32	
77044 ✓	32	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 80181

\*80181\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

10.0000

1

1

\*\*

1

(2P)

12/04/19

\*D3535-25\*

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	1	
-------	---	--

62233	1	
-------	---	--

FP002	9	
-------	---	--

77617	9	
-------	---	--

D3536-25

Manufactured No

230

Each

18.0000

1

1

\*\*

1

(2P)

12/04/19

\*D3536-25\*

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP002	18	
-------	----	--

78902	18	
-------	----	--

D3537-1

Manufactured No

230

Each

19.0000

3

3

\*\*

3

(2P)

12/04/19

\*D3537-1\*

Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP002	19	
-------	----	--

69817	5	
-------	---	--

78591	14	
-------	----	--

D3631-1

Manufactured No

230

Each

223.0000

8

8

\*\*

8

(2P)

12/04/19

\*D3631-1\*

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST072	223	
-------	-----	--

68062	2	
-------	---	--

75548	221	
-------	-----	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID: 80181

**\*80181\***  
**\*D350-636-014\***

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

230 Each

936.0000

8

8

\*\*

**\*D3672-1\*** ✓

Phenolic Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	300	
66821	300	
ST060	636	
72229	136	
76277 ✓	500	

D3791-1

Manufactured No

230 Each

6.0000

1

1

\*\*

**\*D3791-1\***

Wearplate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	6	
62239	2	
75041	4	
82168 ✓		

D3793-1

Manufactured No

230 Each

19.0000

1

1

\*\*

**\*D3793-1\***

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	19	
77029	7	
78901	12	
82171 ✓		

D3793-3

Manufactured No

230 Each

14.0000

1

1

\*\*

**\*D3793-3\***

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	14	
78935	14	
80434 ✓		
82168 ✓		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Work Order ID: 80181

**\*80181\***  
**\*D350-636-014\***

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230 Each

12.0000

\*\*

1

1

(DP)

12/04/19

**\*D3794-1\***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	12	
75042 ✓	12	

D3794-3

Manufactured No

230 Each

7.0000

\*\*

1

1

(DP)

12/04/19

**\*D3794-3\***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	80436 ✓	
74530	2	
78895	5	

MS21043-6

Purchased No

230 Each

817.0000

\*\*

4

4

(DP)

12/04/19

**\*MS21043-6\***

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
103693	20	
ST301	797	
112314	87	
117887	10	
118384 ✓	200	
120308	500	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Work Order ID: 80181

**\*80181\***  
**\*D350-636-014\***

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

48.0000

1

1

\*\*

(P)

12/04/19

**\*MS21083C8\***

NUT

Location Loc Qty Loc Code

FP002 120731 1 \_\_\_\_\_

115884 1 \_\_\_\_\_

ST303 15 \_\_\_\_\_

115884 0 \_\_\_\_\_

118077 1 \_\_\_\_\_

119309 2 \_\_\_\_\_

119436 10 \_\_\_\_\_

119638 2 \_\_\_\_\_

ST304 32 \_\_\_\_\_

120142 32 \_\_\_\_\_

NAS1149C0832R

Purchased

No

230

Each

305.0000

1

1

\*\*

(P)

12/04/19

**\*NAS1149C0832R\***

WASHER

Location Loc Qty Loc Code

ST297 305 \_\_\_\_\_

114915 ✓ 305 \_\_\_\_\_

NAS1515H3L

Purchased

No

230

Each

220.0000

4

4

\*\*

(P)

12/04/19

**\*NAS1515H3L\***

WASHER

Location Loc Qty Loc Code

FG 40 \_\_\_\_\_

102472 40 \_\_\_\_\_

ST277 180 \_\_\_\_\_

118686 3 \_\_\_\_\_

119438 1 \_\_\_\_\_

120072 76 \_\_\_\_\_

120360 ✓ 100 \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 80181

\*80181\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-005

Purchased

No

230

Each

204.0000

8

8

\*\*

8

(P)

12/01/19

\*NAS1611-005\*

O-RING

Location	Loc Qty	Loc Code
FP001	204	
106099 ✓	31	
114220	105	
119438	68	

NAS1611-010

Purchased

No

230

Each

117.0000

8

8

\*\*

8

(P)

12/04/19

\*NAS1611-010\*

O-RING

Location	Loc Qty	Loc Code
FP001	117	
110915	14	
117460	8	
118077	1	
118612	3	
119438	47	
120308	44	

AN8C21A

Purchased

No

250

Each

53.0000

2

2

✓

\*\*

J B

12/04/20

\*AN8C21A\*

BOLT

Location	Loc Qty	Loc Code
ST343	53	
118758	5	
120094	48	

120094

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# ..Picklist Print

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Work Order ID: 80181

\*80181\*  
\*D350-636-014\*

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured

No

250

Each

2.0000

1

1

\*\*

76984 JB

\*D2741\*

Blade, 350 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	-10	
ST466	12	
71856	2	

D3493-1

Manufactured

No

250

Each

32.0000

2

2

\*\*

78835 JB

\*D3493-1\*

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST050	32	
70697	2	
77573	30	

MS21083C8

Purchased

No

250

Each

48.0000

2

2

\*\*

120011 JB 12/04/20

\*MS21083C8\*

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	1	
115884	1	
ST303	15	
115884	0	
118077	1	
119309	2	
119436	10	
119638	2	
ST304	32	
120142	32	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 80181

**\*80181\***  
**\*D350-636-014\***

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

237.0000

2

2

\*\*

JB

12/04/20

~~\*NAS1149D0863J\*~~

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	237	
118078	37	
119307	100	119307
120308	100	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION	
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH	
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH	
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH	
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH	
1	1	1	1	D2739	WEB	
8	8	8	8	D2743	SPACER	
1	1	1	1	D2744	CAP	
8	8	8	8	D2745	BUSHING	
1				D2750-1	SKIDTUBE WELDMENT, LH	
	1			D2750-2	SKIDTUBE WELDMENT, RH	
		1		D2750-3	SKIDTUBE WELDMENT, LH	
			1	D2750-4	SKIDTUBE WELDMENT, RH	
1	1			D3488-041	BLADE FITTING, LH	
	1	1	1	D3488-042	BLADE FITTING, RH	
4	4	4	4	D3490-1	SPACER	
4	4			D3490-3	SPACER	
		4	4	D3490-5	SPACER	
8	8	8	8	D3492-041	PLUG ASSEMBLY	
8	8			D3492-043	PLUG ASSEMBLY	
		8	8	D3492-045	PLUG ASSEMBLY	
1	1	1	1	D3535-25	WEARSHOE	
1	1	1	1	D3536-25	GASKET	
3	3	3	3	D3537-1	WEARPAD	
8	8	8	8	D3631-1	WASHER	
1	1	1	1	D3791-1	WEARPLATE	
1	1	1	1	D3793-1	WEARSHOE	
1	1	1	1	D3793-3	WEARSHOE	
1	1	1	1	D3794-1	GASKET	
1	1	1	1	D3794-3	GASKET	
F	38	38	38	38	ALS4-1032-225	
	34	34	34	34	AN3C5A	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
	4	4	4	4	AN3C6A	BOLT
	4	4	4	4	AN6C44A	BOLT
	1	1	1	1	AN8C35A	BOLT
F	38	38	38	38	AN960C10L	WASHER
	1	1	1	1	AN960C816L	WASHER
	4	4	4	4	MS21043-6	NUT
	1	1	1	1	MS21083C8	NUT
	4	4	4	4	NAS1515H3L	WASHER

801.81-H.L.J  
12/02/13

RELEASED  
07/22/14

**GENERAL NOTES:**

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
  - ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
  - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
  - BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (.0297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
  - MINIMUM YIELD TENSILE STRENGTH = 35 KSI
  - MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERT. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL 
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL 

F	INCORPORATE DSI 9413; QTY (3) D3537-1 AND QTY (5) (ZN C8-1); D3791-1/2 AND QTY (3) D3535-13/-35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/-35 (ZN BB-1); ADD D3791-1 (ZN C8-1);		PH	08.07.16	
	WEARSHOE HOLES UNDER FWFD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN BB-1); D3488-0417-042 HARDWARE UPDATED (ZN C1-B, 9, 10, 11); ADD NOTE: 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043				
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; MOVE QTY (38) NAS1515H31; REMOVE QTY (10) NAS1515H31BL; REMOVE D2741, QTY (2) AN960C816; MOVE QTY (2) MS21083C8		CB	07.05.17	
D	ADD HOLES AND SI <sup>AC</sup> ERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157		PH	06.01.05	
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740		CP	98.11.18	
B	CHANGE MS24694-5293 TO AN8-16A		CP	98.09.01	
A	NEW ISSUE		DS	98.04.16	
REV.	DESCRIPTION		BY	DATE	
DESIGN	<i>PC</i>		<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA		
DRAWN	<i>PC</i>		DRAWING NO. <b>D2750</b> REV. F		
CHECKED	<i>PC</i>		SHEET 1 OF 11		
MFG. APPR.	<i>AP</i>		TITLE <b>350 SKIDTUBE ASSEMBLY</b> NTS		
APPROVED	<i>AP</i>		NATIVE PERSMISSION FROM DART AEROSPACE USA, INC.		
DE APPR.	<i>AP</i>		COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. AND IS LOANED TO THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS PROVIDED. IT IS THE PROPERTY OF DART AEROSPACE USA, INC.		
DATE	08.07.16				

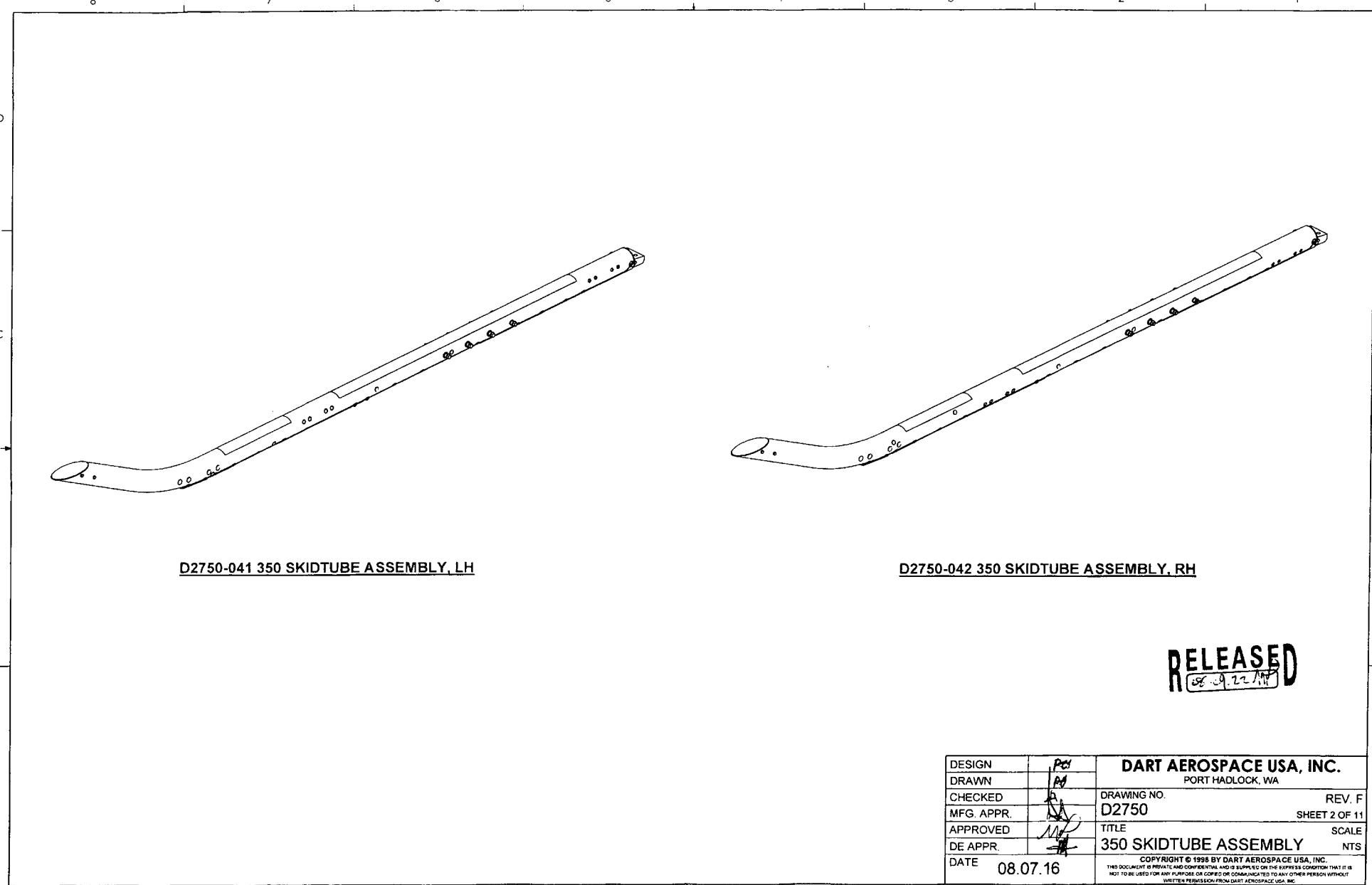
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NOTE: Date & initial all entries

80181



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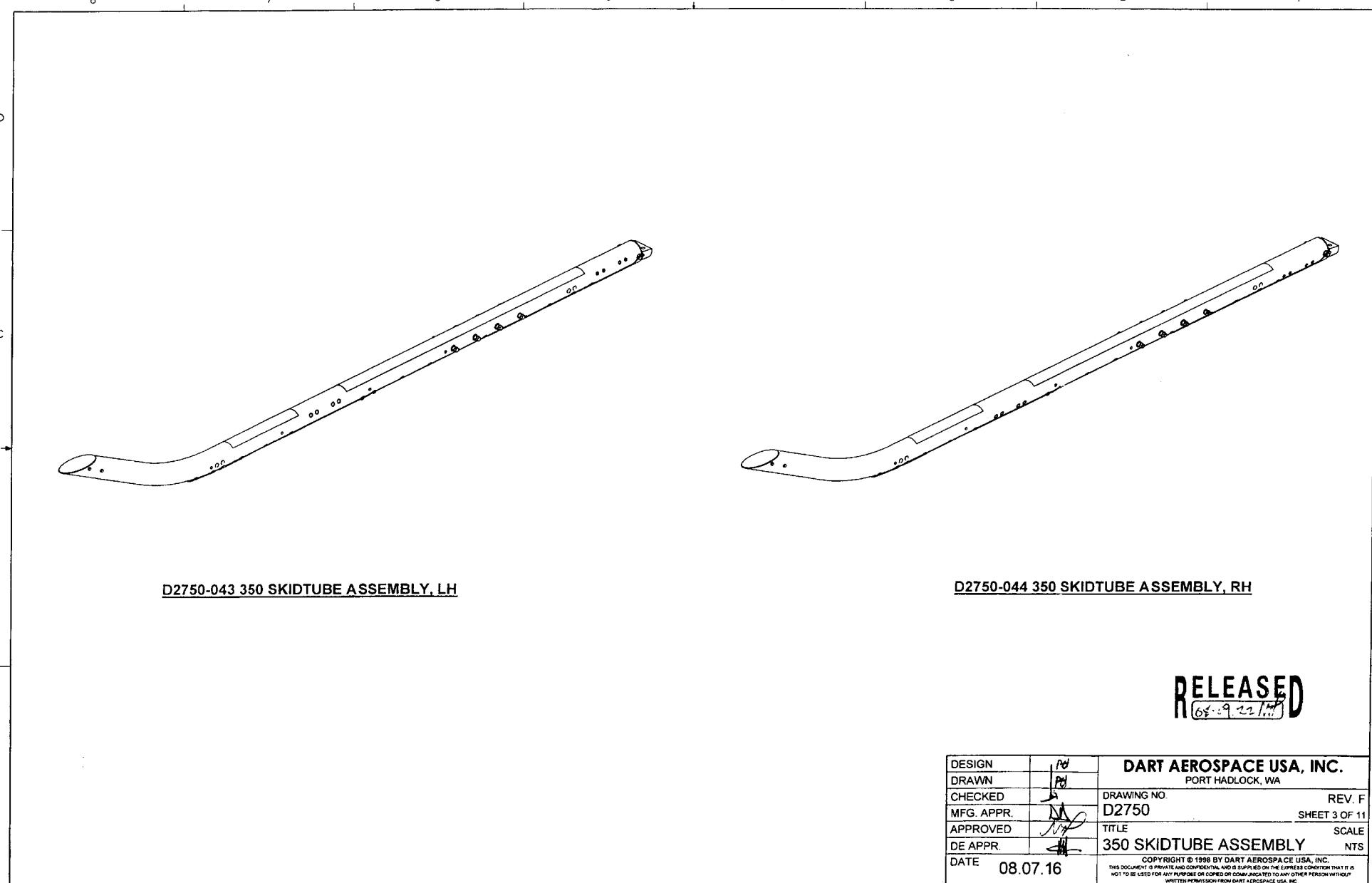
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80101



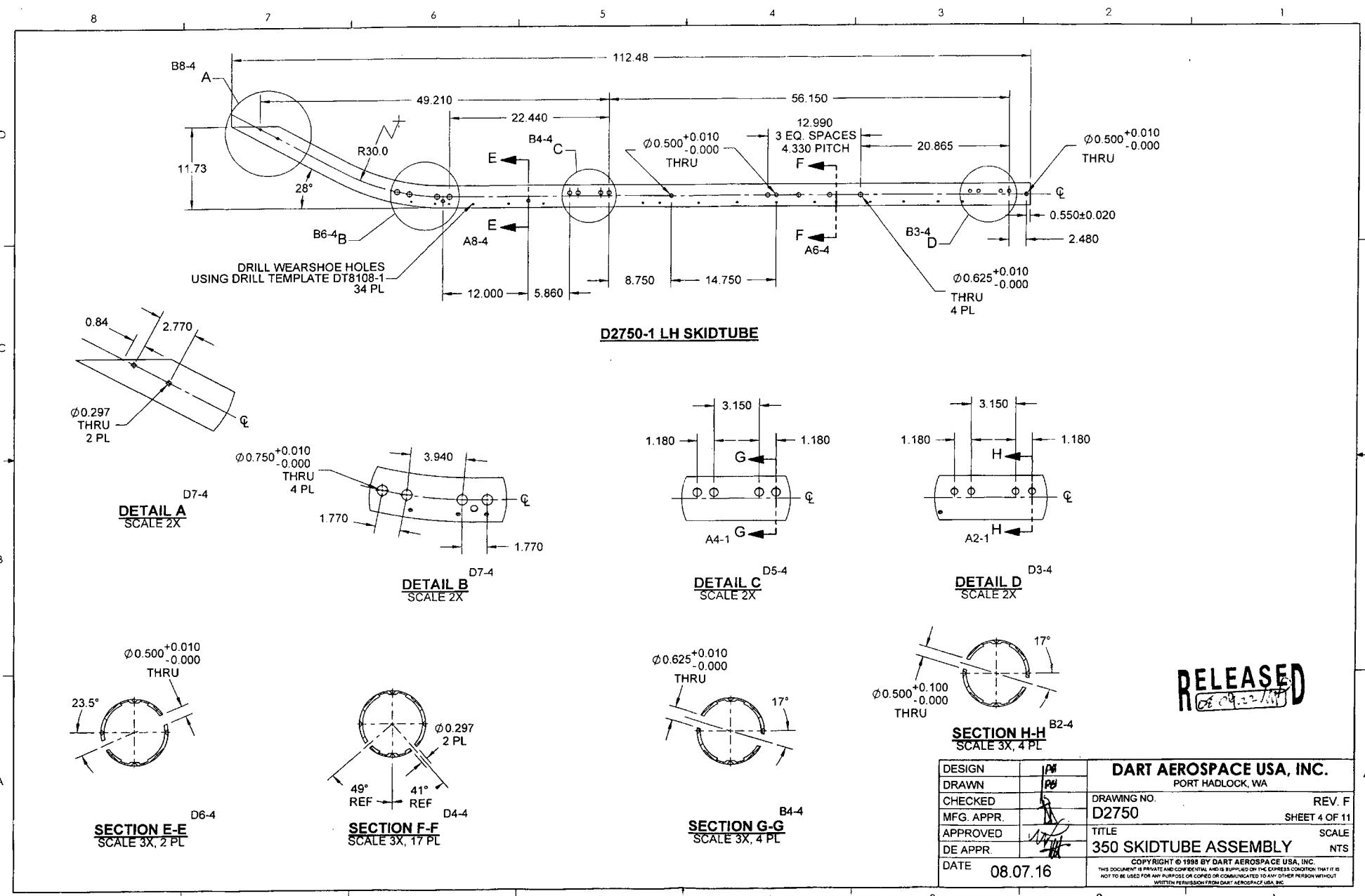
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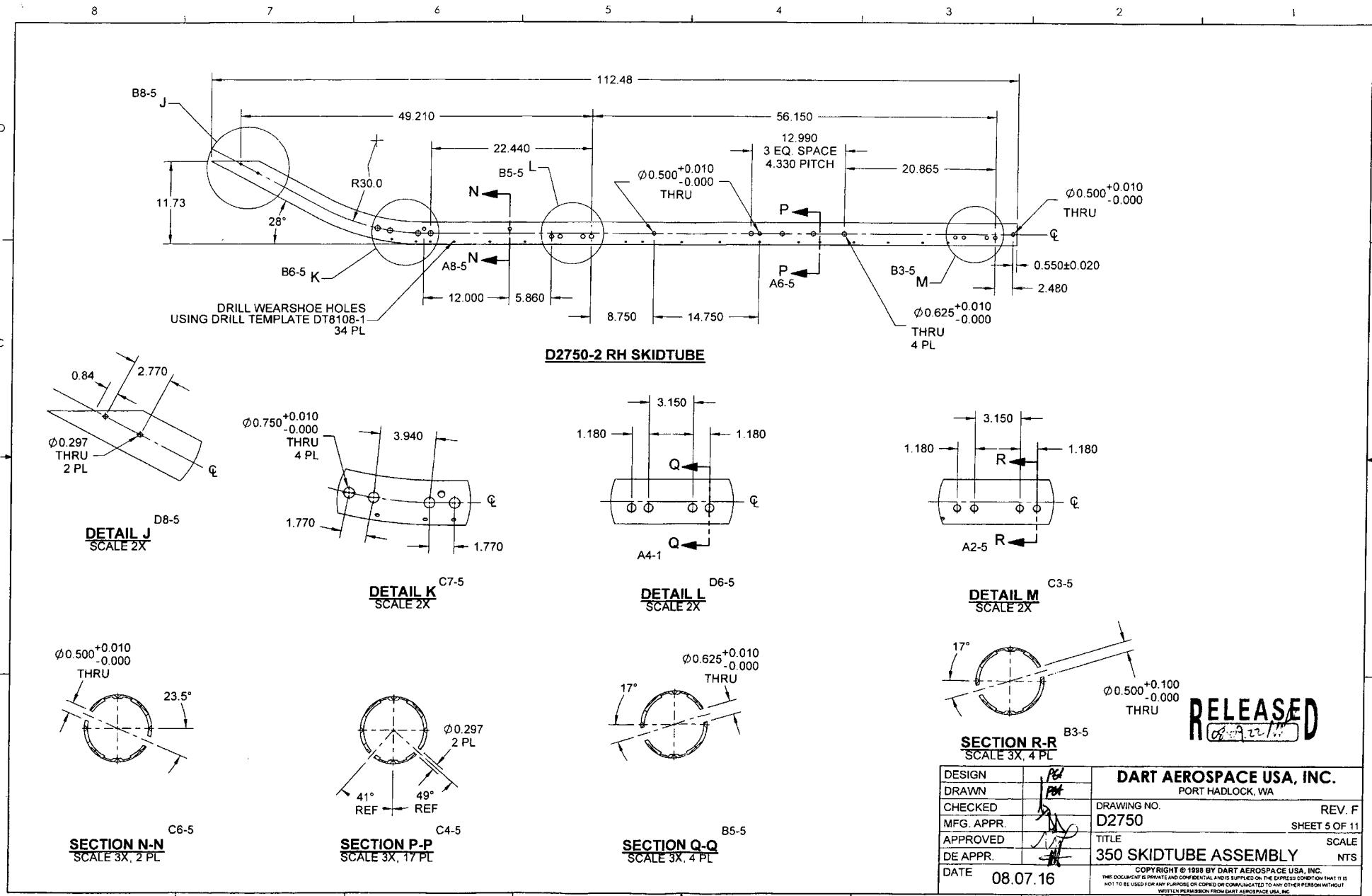
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DRAWN	PER	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. F	
MFG. APPR.		D2750	SHEET 5 OF 11	
APPROVED		TITLE	SCALE	
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS	
DATE	08.07.16	COPYRIGHT © 1989 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		

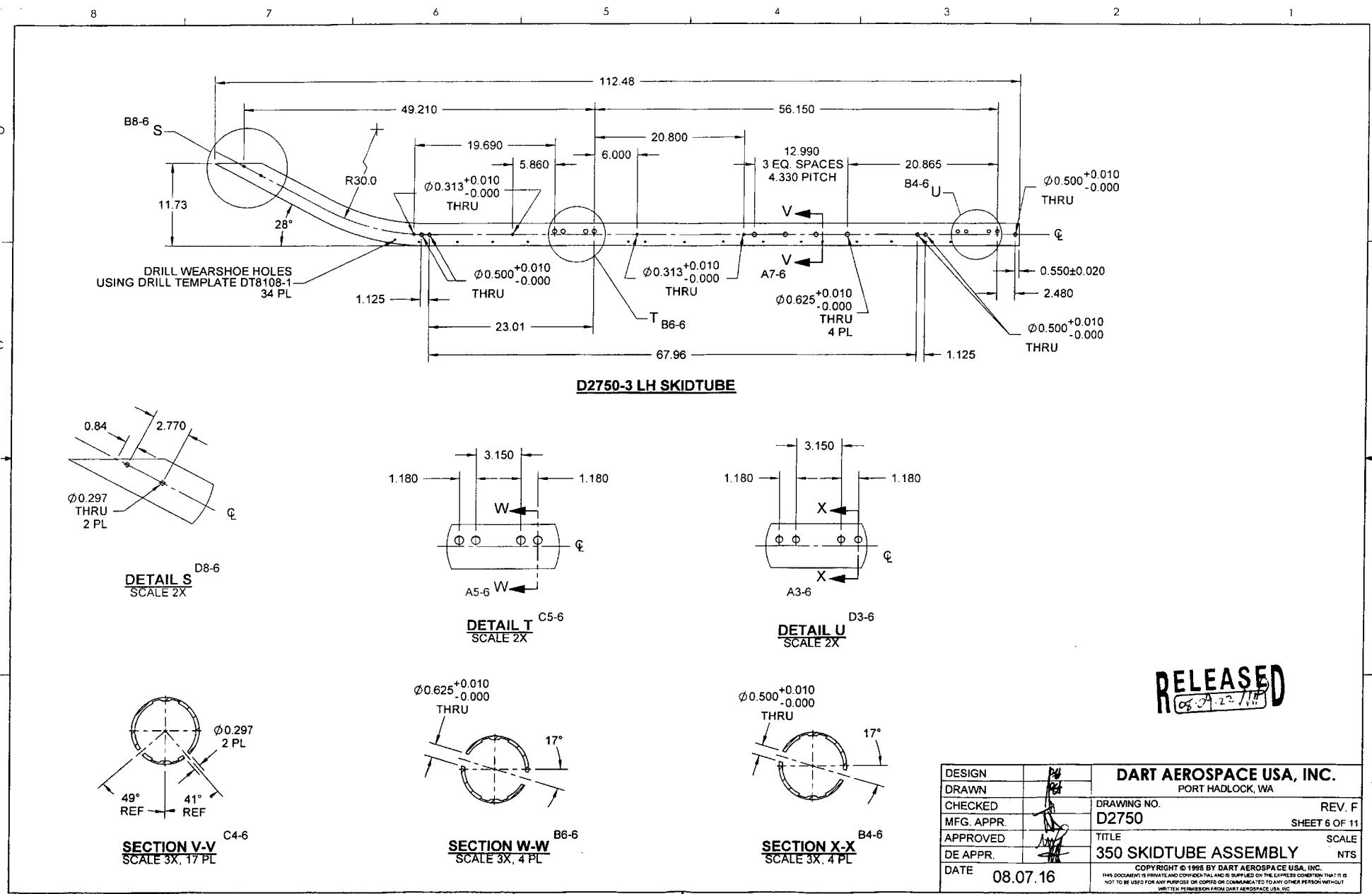
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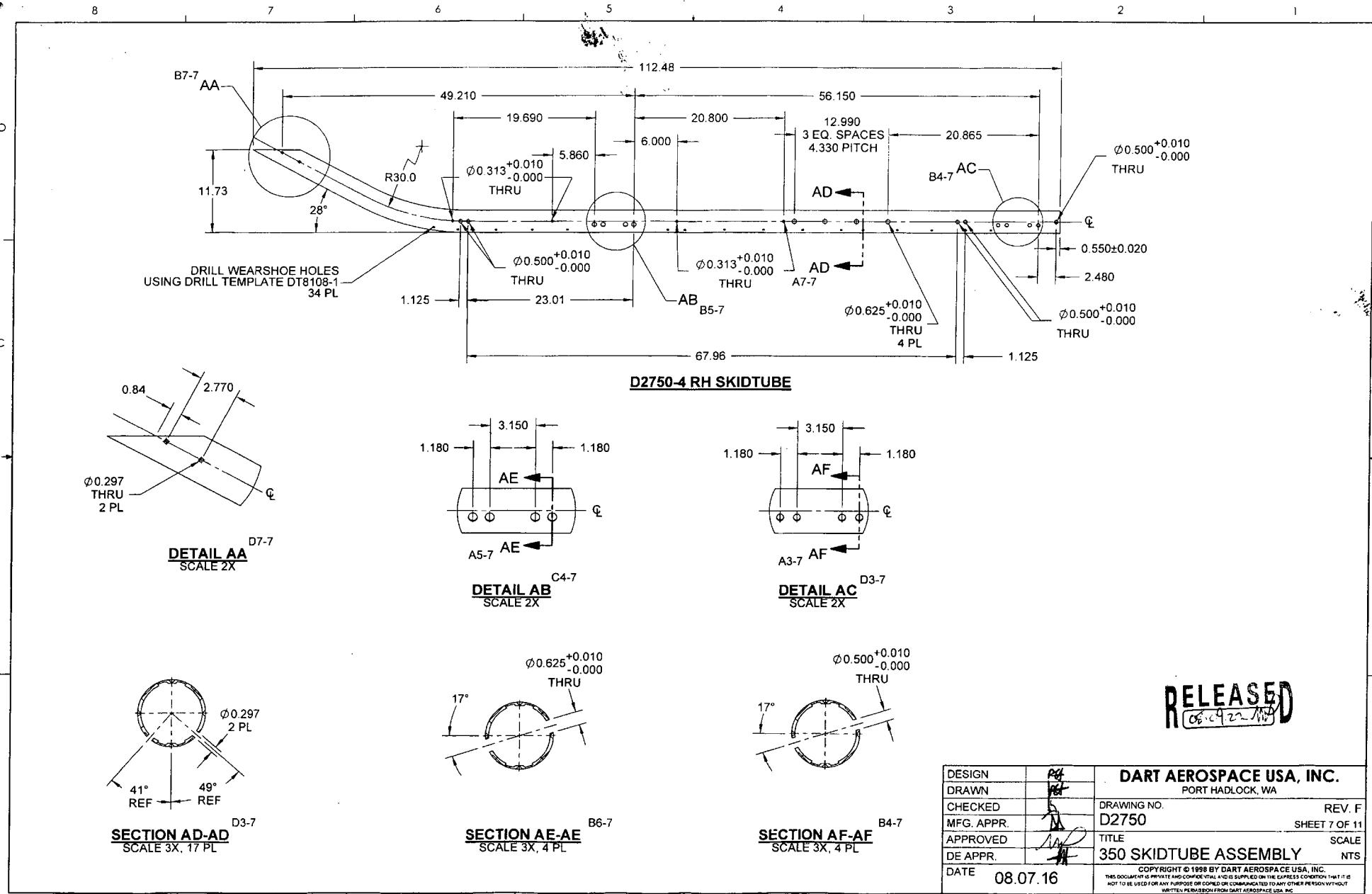
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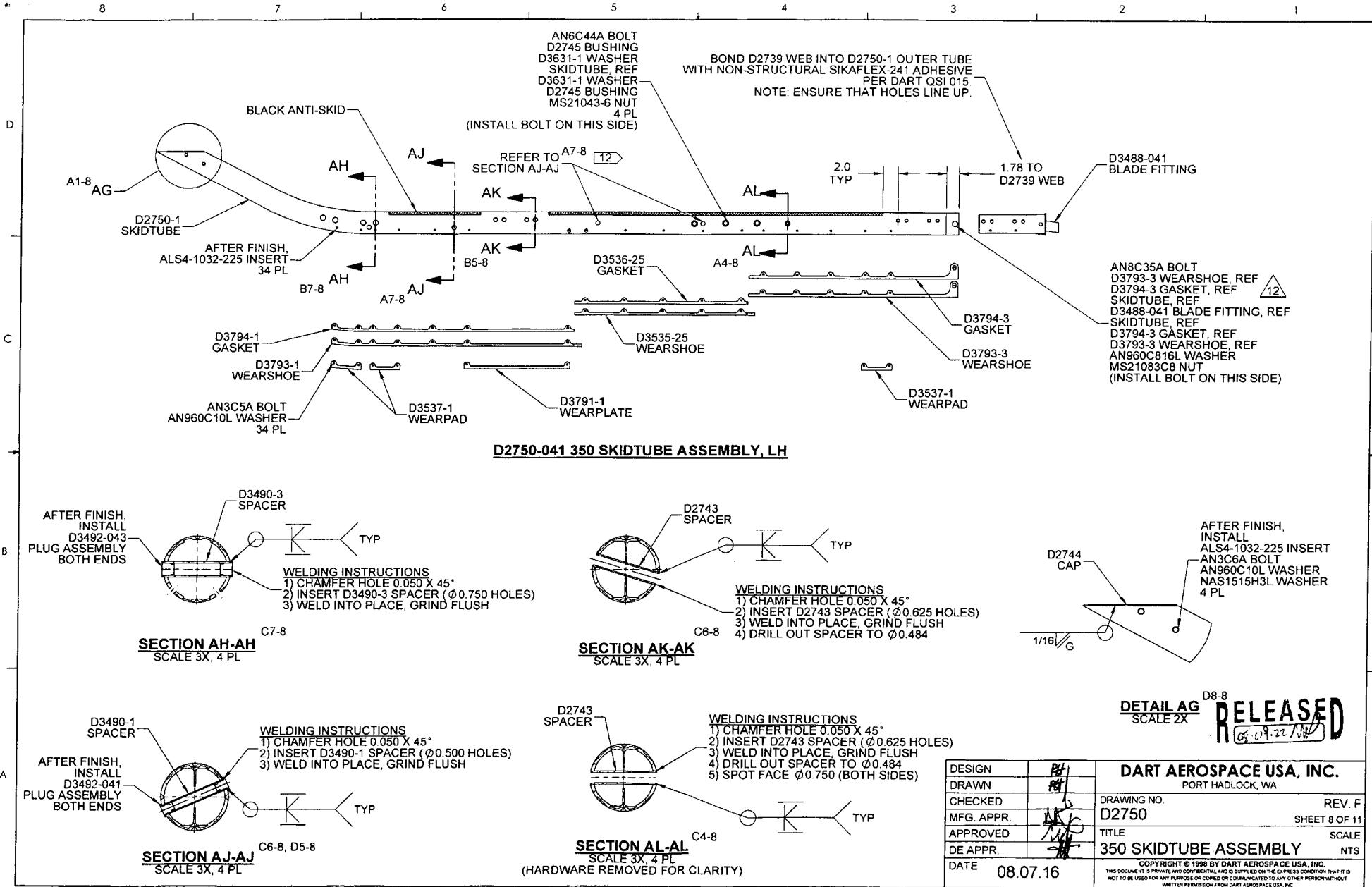
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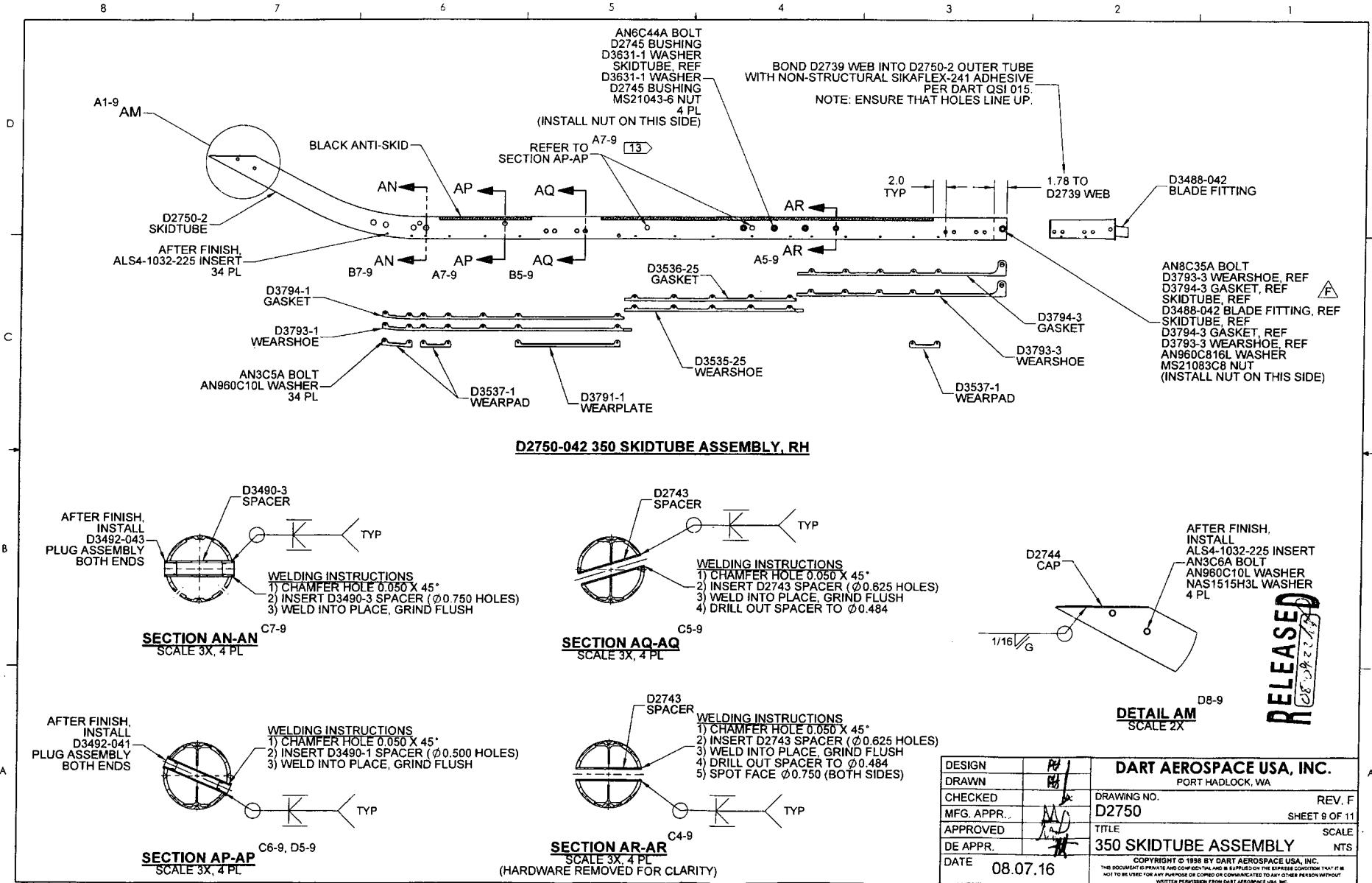
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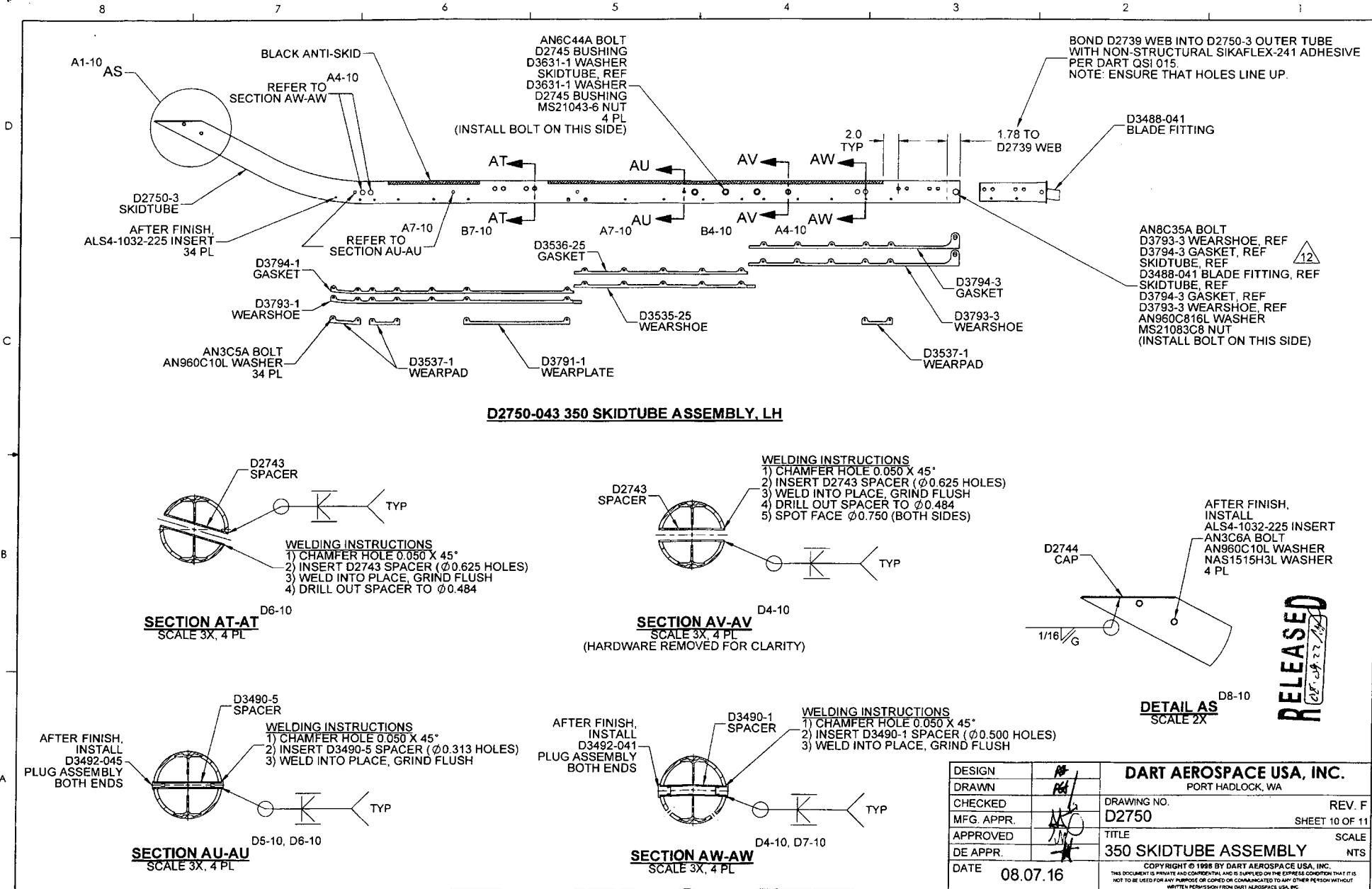
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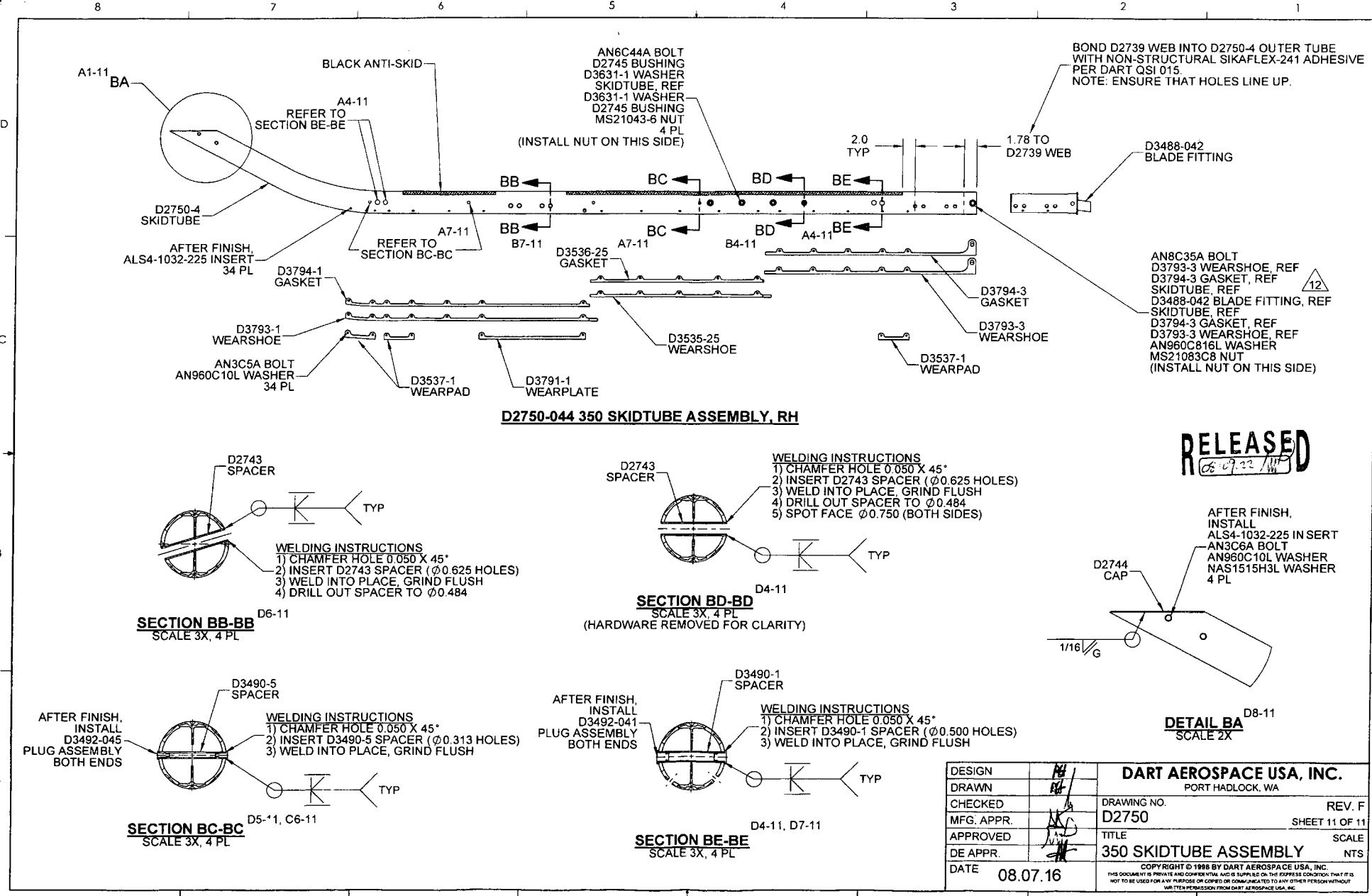
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NO. 289

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 81400  
Part number: A350 - 636 - 016  
Description: Studhuse  
Welding Process: Tig  Mig   
Base material: Alum  
Current: AC  DC

TEST REQUIREMENTS AND RESULTS

Visual: pass  fail   
Penetration: pass  fail

UNACCEPTABLE

Cracks: pass  fail   
Undercut: pass  fail   
Pin holes: pass  fail   
Overlap (cold lap): pass  fail   
Porosity (surface): pass  fail   
Coloration: pass  fail

Qualifier David Newell Date of Test Coupon 12.04.17

Welder Barclay Elliott Date of Test Coupon 12.04.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld